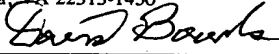


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**PATENT**  
**091-0199**

  
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## **COOLANT FEED DRILL NOZZLE WITH THRUST-VECTORED EXHAUST**

### BACKGROUND OF THE INVENTION

- 5   **[001]**   The present invention generally relates to devices that can be  
attached to a drill motor and methods for providing coolant to a drill bit and for  
chip extraction during a drilling process and, more particularly, to a coolant feed  
drill nozzle with a thrust-vectored intake and a method for providing coolant to a  
drill bit and for vacuum extraction of drilling debris during drilling on non-flat  
10   surfaces.
- 15   **[002]**   Advanced aircraft, for example, the F-18, require many holes to be  
drilled into the fuselage of the aircraft. A numerically controlled drill jig exists for  
use on the forward fuselage of an F-18 aircraft. The numerically controlled drill  
jig offers an ergonomic, portable, foundation-free system for drilling holes into  
15   the skin of the aircraft that easily adapts to changes in the fabrication process  
while improving hole quality. This system utilizes a drill head unit that provides  
pressure to the fuselage skin of an aircraft, injects coolant towards a drill bit,  
and exhausts chips and dust occurring during the drilling process. Although the  
numerically controlled drill jig enables simple and low cost automation of the  
20   manufacturing process, the drill head unit of this system can only be used on  
the skins of the aircraft. Since the drill head unit of the numerically controlled  
drill jig is designed to apply pressure to the fuselage skins during the drilling  
process, a flat contact surface is necessary for the use of this drill head unit.  
Currently, if the numerically controlled drill jig is used for drilling holes into non-  
25   flat surfaces, for example, the leading edge extension spar of the F-18 aircraft

that comprises recessed pockets and stiffened walls, the existing drill head unit must be removed. Since coolant injection and vacuum extraction of drilling debris is still needed, the machine operator must apply the coolant injection and vacuum extraction manually. However, manually applying the coolant to the drill bit and manually vacuum extracting the drilling debris is a dangerous, inconvenient, and time-consuming process.

**[003]** There has, therefore, arisen a need to provide a drill head unit for use with the existing numerically controlled drill jig that enables the effective use of the numerically controlled drill jig on non-flat surfaces, for example, the leading edge extension spar of the F-18 aircraft. There has further arisen a need to provide a drill head unit that allows coolant injection towards the drill bit and vacuum extraction of the drilling debris such that the operation is safe, convenient, and timesaving. There has also arisen a need to provide a drill head unit, such as a drill nozzle, that may be easily attached to the existing numerically controlled drill jig and therefore, allows a low cost automation of the drilling process on non-flat surfaces during the manufacturing process of an aircraft. There has further arisen a need to provide a method for providing coolant to a drill bit during the drilling process on non-flat surfaces, for example the leading edge extension spar of the F-18 aircraft, while vacuum extracting the drilling debris, for example, chips, dust, and coolant, such that no drilling debris may damage the surrounding surfaces or may injure a machine operator.

**[004]** Prior art further describes several drill motor vacuum attachments, for example U.S. Patent No. 5,988,954 and U.S. Patent application No. US 6,200,075 B1, both issued to Gaskin et al., and U.S. Patent No. 5,033,917 issued to McGlasson et al. Even though these patents describe devices for vacuum extraction of drilling debris, for example, chip swarf and dust particles, these devices either don't allow coolant injection towards the drill bit (U.S. Patent No. 5,988,954 and U.S. Patent application No. US 6,200,075 B1) or these devices are too complex and not suitable to address the needs described above.

[005] Prior art further discloses several devices for clamping a drill motor to a drill plate, for example, U.S. Patent No. 5,395,187 issued to Slesinski et al., U.S. Patent No. 5,482,411 issued to McGlasson, and U.S. Patent No. 5,584,618 issued to Blankenship et al. These prior art devices comprise an apparatus for  
5 securely clamping a drill motor to a drill plate in order to drill precisely positioned holes in a work piece. These prior art devices comprise attachments to a drill motor but do not provide coolant injection towards a drill bit or vacuum extraction of the drilling debris during the drilling process. Further, these prior art devices are not suitable for the use on non-flat surfaces, for example, the  
10 leading edge extension spar of the F-18 aircraft, to address the needs described above.

[006] As can be seen, there is a need for a drill nozzle that allows coolant injection towards a drill bit such that the drill bit may be engulfed during the drilling operation. Also, there is a need for a drill nozzle that allows vacuum  
15 extraction of drilling debris during the drilling operation, such that no chips, dust, or remaining coolant fluid may damage or soil the surrounding surfaces or may injure a machine operator. Further, there is a need for a drill nozzle that may be attached to the drill motor unit of a prior art numerically controlled drill jig to enable the use of the numerically controlled drill jig for non-flat surface of an  
20 advanced aircraft, for example, the leading edge extension spar of the F-18 aircraft. Moreover, there is a need for a method for providing coolant to a drill bit during the drilling process on non-flat surfaces, for example, the leading edge extension spar of the F-18 aircraft, while vacuum extracting the drilling debris, for example, chips, dust, and coolant, and, therefore, improving the drill  
25 hole quality.

#### SUMMARY OF THE INVENTION

[007] The present invention provides a drill nozzle that can be attached to  
30 a drill motor unit and that allows coolant injection towards a drill bit during the

drilling operation while vacuum extracting the drilling debris at the same time, such that no chips, dust, or remaining coolant fluid may exit the drill nozzle towards the drill motor unit. The present invention further provides a drill nozzle that is suitable for, but not limited to, being attached to a drill motor unit of a  
5 prior art numerically controlled drill jig, enabling the use of such numerically controlled drill jig for drilling high quality holes effectively into non-flat surfaces, for example, the leading edge extension spar of the F-18 aircraft. The present invention still further provides a method for providing coolant to a drill bit during the drilling process on non-flat surfaces while vacuum extracting the drilling  
10 debris, such that no drilling debris may damage or spoil the drill motor unit, to which the drill nozzle of the present invention may be attached, or any surrounding structures and surfaces.

**[008]** In one aspect of the present invention, a drill nozzle comprises a housing having a bristle brush ring attached. The housing includes a first  
15 section and a second section. The first section has a cylindrical elongated shape, a hollow interior, a first axis, and extends along the first axis. The first section has a first open end and a second open end opposite from the first open end, the first open end and the second open end being terminal ends spaced apart along the first axis and defining a spherical internal chamber therein. The  
20 first section includes an air intake having a cylindrical shape, the air intake being located proximate to the second open end and above the second section, the air intake extending the housing downward in a right angle to the first axis. The first section further includes a first coolant inlet having a cylindrical shape and extending the housing sideward in a right angle to the first axis, a first  
25 integrally molded coolant passageway, and a first set of at least two coolant jets, the first coolant passageway connecting the first coolant inlet with the first set of coolant jets, wherein the first set of coolant jets is integrally molded into the first open end. The first section further includes a second coolant inlet having a cylindrical shape and extending the housing sideward in a direction  
30 opposite to the first coolant inlet and in a right angle to the first axis, a second

integrally molded coolant passageway, and a second set of at least two coolant jets, the second coolant passageway connecting the second coolant inlet with the second set of coolant jets, wherein the second set of coolant jets is integrally molded into the first open end. The second section has a cylindrical elongated shape, a hollow interior, and a second axis being in a right angle with the first axis, the second section extending downward from the first section along the second axis and the second section being located proximate to the second open end of the first section. The second section includes a vacuum tube being in connection with the spherical internal chamber of the first section.

5 The second section further includes at least two mounting flanges having an aperture, the mounting flanges being located proximate to the intersection of the first section and the second section and the mounting flanges extending sideward from the housing to opposite sides in a right angle to the first axis and the second axis. The bristle brush ring is attached to the first section of the housing proximate to the first open end.

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**[009]** In another aspect of the present invention, a drill nozzle comprises a housing having a bristle brush ring attached and a mounting device attaching the housing to a drill motor unit. The housing includes a first section and a second section. The first section has a cylindrical elongated shape, a hollow interior, a first axis, and extends along the first axis. The first section has a first open end and a second open end opposite from the first open end, the first open end and the second open end being terminal ends spaced apart along the first axis and defining a spherical internal chamber therein. The first section includes an air intake having a cylindrical shape, the air intake being located proximate to the second open end and above the second section, the air intake extending the housing downward in a right angle to the first axis. The first section further includes a first coolant inlet having a cylindrical shape and extending the housing sideward in a right angle to the first axis, a first integrally molded coolant passageway, and a first set of at least two coolant jets, the first coolant passageway connecting the first coolant inlet with the first set of coolant

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jets, wherein the first set of coolant jets is integrally molded into the first open end. The first section further includes a second coolant inlet having a cylindrical shape and extending the housing sideward in a direction opposite to the first coolant inlet and in a right angle to the first axis, a second integrally molded  
5 coolant passageway, and a second set of at least two coolant jets, the second coolant passageway connecting the second coolant inlet with the second set of coolant jets, wherein the second set of coolant jets is integrally molded into the first open end. The second section has a cylindrical elongated shape, a hollow interior, and a second axis being in a right angle with the first axis, the second  
10 section extending downward from the first section along the second axis and the second section being located proximate to the second open end of the first section. The second section includes a vacuum tube being in connection with the spherical internal chamber of the first section. The second section further includes at least two mounting flanges having an aperture, the mounting flanges  
15 being located proximate to the intersection of the first section and the second section and the mounting flanges extending sideward from the housing to opposite sides in a right angle to the first axis and the second axis. The bristle brush ring is attached to the first section of the housing proximate to the first open end.

20 **[010]** In still another aspect of the present invention, a numerically controlled drill jig comprises a drill motor unit, a drill nozzle attached to the drill motor unit, a bristle brush ring, and a mounting device. The housing includes a first section and a second section. The first section has a cylindrical elongated shape, a hollow interior, a first axis, and extends along the first axis. The first  
25 section has a first open end and a second open end opposite from the first open end, the first open end and the second open end being terminal ends spaced apart along the first axis and defining a spherical internal chamber therein. The first section includes an air intake having a cylindrical shape, the air intake being located proximate to the second open end and above the second section,  
30 the air intake extending the housing downward in a right angle to the first axis.

The first section further includes a first coolant inlet having a cylindrical shape and extending the housing sideward in a right angle to the first axis, a first integrally molded coolant passageway, and a first set of at least two coolant jets, the first coolant passageway connecting the first coolant inlet with the first set of coolant jets, wherein the first set of coolant jets is integrally molded into the first open end. The first section further includes a second coolant inlet having a cylindrical shape and extending the housing sideward in a direction opposite to the first coolant inlet and in a right angle to the first axis, a second integrally molded coolant passageway, and a second set of at least two coolant jets, the second coolant passageway connecting the second coolant inlet with the second set of coolant jets, wherein the second set of coolant jets is integrally molded into the first open end. The second section has a cylindrical elongated shape, a hollow interior, and a second axis being in a right angle with the first axis, the second section extending downward from the first section along the second axis and the second section being located proximate to the second open end of the first section. The second section includes a vacuum tube being in connection with the spherical internal chamber of the first section. The second section further includes at least two mounting flanges having an aperture, the mounting flanges being located proximate to the intersection of the first section and the second section and the mounting flanges extending sideward from the housing to opposite sides in a right angle to the first axis and the second axis. The bristle brush ring is attached to the first section of the housing proximate to the first open end. The bristle brush ring is attached to the first section of the housing proximate to the first open end. The mounting device attaches the housing to the drill motor unit. The mounting device includes two horse shoe brackets that attach to a base section of the drill motor unit, a mounting plate in rigid connection with the horse shoe brackets, and two adjustable slides attached to the mounting plate at opposite sides, wherein the adjustable slides connect the mounting plate with the mounting flanges of the housing.

[011] In a further aspect of the present invention, a coolant feed drill nozzle with thrust-vectorized intake comprises a housing, a bristle brush ring, a band clamp, an external pressurized air source, an external coolant source, and an external vacuum source. The housing includes a first section and a second section. The first section has a cylindrical elongated shape, a hollow interior, a first axis, and extends along the first axis. The first section has a first open end and a second open end opposite from the first open end, the first open end and the second open end being terminal ends spaced apart along the first axis and defining a spherical internal chamber therein. The first section includes an air intake having a cylindrical shape, the air intake being located proximate to the second open end and above the second section, the air intake extending the housing downward in a right angle to the first axis. The first open end of the first section of the housing has a first outer diameter and a first inner diameter being smaller than the first outer diameter, wherein the second open end of the first section of the housing has a second outer diameter and a second inner diameter being smaller than the second outer diameter, and wherein the first inner diameter is larger than the second inner diameter. The first section includes an air intake having a cylindrical shape and a barbed fitting, the air intake being located proximate to the second open end and above the second section, the air intake extending the housing downward in a right angle to the first axis. The air intake includes an integrally molded manifold air nozzle, the air nozzle providing a thrust-vectorized down draft into the second section of the housing. The first section further includes a first coolant inlet having a cylindrical shape, a barbed fitting, and an integrally molded coolant nozzle, the first coolant inlet extending the housing sideward in a right angle to the first axis, a first integrally molded coolant passageway, and a first set of at least two coolant jets, the first coolant passageway connecting the first coolant inlet with the first set of coolant jets, wherein the first set of coolant jets is integrally molded into the first open end. The first section further includes a second coolant inlet having a cylindrical shape, a barbed fitting, and an integrally



molded coolant nozzle, the second coolant inlet extending the housing sideward in a direction opposite to the first coolant inlet and in a right angle to the first axis, a second integrally molded coolant passageway, and a second set of at least two coolant jets, the second coolant passageway connecting the second coolant inlet with the second set of coolant jets, wherein the second set of coolant jets is integrally molded into the first open end. The first set of coolant jet and the second set of coolant jets are evenly spaced around the circumference of the first open end and between the first outer diameter and the first inner diameter of the first end, and wherein each of the coolant jets is positioned to expel coolant fluid toward the first axis. The second section has a cylindrical elongated shape, a hollow interior, and a second axis being in a right angle with the first axis, the second section extending downward from the first section along the second axis and the second section being located proximate to the second open end of the first section. The second section includes a vacuum tube being in connection with the spherical internal chamber of the first section. The second section further includes at least two mounting flanges having an aperture, the mounting flanges being located proximate to the intersection of the first section and the second section and the mounting flanges extending sideward from the housing to opposite sides in a right angle to the first axis and the second axis. The bristle brush ring is attached to the first section of the housing proximate to the first open end. The bristle brush ring is attached to the first section of the housing proximate to the first open end. The band clamp secures the bristle brush ring to the housing. The external pressurized air source provides pressurized air to the air intake. The external coolant source provides coolant to the first coolant inlet and the second coolant inlet. The external vacuum source provides suction to the vacuum tube.

**[012]** In still another aspect of the present invention, a method for providing coolant to a drill bit and for vacuum extracting drilling debris generated during a drilling process on non-flat surfaces comprises the steps of: providing a drill motor unit including a drill bit; providing a drill nozzle including: a housing

having an air intake, multiple coolant inlets, multiple coolant passageways, multiple coolant jets, a vacuum tube, and mounting flanges; and a bristle brush ring attached to the housing; attaching the drill nozzle to the drill motor unit using the mounting flanges; providing pressurized air to the air intake and  
5 creating a thrust-vectorized down draft into the vacuum tube; providing coolant fluid through the coolant inlets and through the coolant passageways toward the coolant jets; expelling coolant fluid onto the drill bit; providing suction to the vacuum source; drilling a hole into a non-flat surface and generating drilling debris; vacuum extracting the drilling debris through the vacuum tube; preventing  
10 drilling debris from exiting the housing of the drill nozzle towards the drill motor unit by providing the thrust-vectorized down draft; containing the drilling debris and coolant fluid inside the bristle brush ring, wherein the bristle brush ring touches the non-flat surface; and preventing damaging and soiling surrounding structures and surfaces with the bristle brush ring.

15 **[013]** These and other features, aspects and advantages of the present invention will become better understood with reference to the following drawings, description and claims.

#### BRIEF DESCRIPTION OF THE DRAWINGS

20 **[014]** Figure 1 is an external perspective view of a drill nozzle according to one embodiment of the present invention;

**[015]** Figure 2 is an external side view of the drill nozzle according to one embodiment of the present invention;

25 **[016]** Figure 3 is an external front view of the drill nozzle according to one embodiment of the present invention;

**[017]** Figure 4 is an external top view of the drill nozzle according to one embodiment of the present invention;

30 **[018]** Figure 5 is an internal perspective view of the drill nozzle according to one embodiment of the present invention;

[019] Figure 6 is an internal side view of the drill nozzle according to one embodiment of the present invention;

[020] Figure 7 is an internal front view of the drill nozzle according to one embodiment of the present invention;

5 [021] Figure 8 is an internal top view of the drill nozzle according to one embodiment of the present invention;

[022] Figure 9 is a perspective view of the drill nozzle attached to a drill motor unit according to another embodiment of the present invention;

10 [023] Figure 10 is a side view of the drill nozzle attached to the drill motor unit according to another embodiment of the present invention;

[024] Figure 11 is a front view of the drill nozzle attached to the drill motor unit according to another embodiment of the present invention; and

[025] Figure 12 is a perspective view of the drill nozzle attached to the drill motor unit according to still another embodiment of the present invention.

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#### DETAILED DESCRIPTION OF THE INVENTION

[026] The following detailed description is of the best currently contemplated modes of carrying out the invention. The description is not to be  
20 taken in a limiting sense, but is made merely for the purpose of illustrating the general principles of the invention, since the scope of the invention is best defined by the appended claims.

[027] Broadly, an embodiment of the present invention provides a drill nozzle suitable for drilling into non-flat surfaces. The drill nozzle according to an  
25 embodiment of the present invention may be attached to a drill motor unit, and therefore, eliminates the dangerous manual operation of the coolant and vacuum processes of the prior art. An embodiment of the present invention also provides a drill nozzle that allows coolant injection towards a drill bit during the drilling operation on non-flat surfaces while vacuum extracting the drilling  
30 debris at the same time such that no chips, dust, or remaining coolant fluid may

exit the drill nozzle towards the drill motor unit, and such that surrounding surfaces and structures may not be spoiled or damaged. In contrast to the known prior art, the drill nozzle according to one embodiment of the present invention includes a housing having an air intake, coolant inlets, and a vacuum tube. The air intake provides an air curtain that prevents the drilling debris from existing the drill nozzle towards the drill motor unit while the vacuum tube extracts the drilling debris and the coolant fluid provided by the coolant inlets away from the work area. Furthermore, the drill nozzle according to one embodiment of the present invention may have a bristle brush ring attached, which is not available in any known prior art drill motor attachment. The bristle brush ring prevents surrounding structures and surfaces from being soiled or damaged. In contrast to the prior art, these features of the drill nozzle according to one embodiment of the present invention facilitate using the drill nozzle for drilling into non-flat surfaces.

15 **[028]** An embodiment of the present invention further provides a drill nozzle that is suitable for, but not limited to, being attached to a drill motor unit of a prior art numerically controlled drill jig, enabling the use of such numerically controlled drill jig for drilling high quality holes into non-flat surfaces, for example, the leading edge extension spar of an F-18 aircraft. In the prior art, such a drill nozzle is not available. An embodiment of the present invention further provides a drill nozzle that has a simple mechanical design and may be manufactured using a fused deposition modeled process for rapid prototyping, which is relatively easily accessible and relatively inexpensive. An embodiment of the present invention still further provides a method for providing coolant to a drill bit during the drilling process on non-flat surfaces using a numerically controlled drill jig while vacuum extracting the drilling debris such that no drilling debris may damage or spoil the drill motor unit, to which the drill nozzle of the present invention may be attached, or any surrounding structures. In contrast to the prior art, the provided drill nozzle as in one embodiment of the present invention includes a housing having an air intake, multiple coolant inlets,

multiple coolant passageways, multiple coolant jets, a vacuum tube, and mounting flanges, and has a bristle brush ring attached. These features of the drill nozzle as in one embodiment of the present invention allow connecting the drill nozzle to a numerically controlled drill jig, providing an air curtain to avoid damage to the attached drill motor, providing coolant fluid onto a drill bit, providing suction for debris removal, and containing the drilling debris and coolant fluid inside the bristle brush ring, preventing damaging and soiling of surrounding surfaces and structures.

5 [029] A drill nozzle according to one embodiment of the present invention will make it possible to use a prior art numerically controlled drill jig for drilling high quality holes into non-flat surfaces, for example, the leading edge extension spar of the F-18 aircraft. Therefore, no dangerous and ineffective manual operation of the coolant delivery and of the vacuum extraction process is needed as there is with the prior art use of a numerically controlled drill jig for drilling holes into the leading edge extension spar of the F-18 aircraft. Since the drill nozzle of the present invention may be easily attached to a drill motor unit of the prior art numerically controlled drill jig after the existing drill head unit is removed, the drilling process on non-flat surfaces, for example, the leading edge extension spar of the F-18 aircraft, has now a reduced cycle time while providing accurately positioned high quality drill holes compared to prior art manual operation.

15 [030] In one embodiment, the present invention provides a drill nozzle that comprises a thrust-vectorized intake that receives pressurized air and provides a thrust-vectorized draft down into a vacuum tube. Therefore, an air curtain may be provided that prevents the rear escape of metal chips and composite dust that are generated during the drilling process, eliminating the potential of personal injury inherent to prior art manual operation. None of the known prior art devices provides an air curtain that prevents the rear escape of metal chips and composite dust. Furthermore, the drill motor unit to which the drill nozzle of the present invention is attached may now be protected from being damaged by

escaping metal chips or composite dust during the drilling process, which is not easily done during prior art manual operation.

5     **[031]**     In one embodiment, the present invention provides a drill nozzle that may have a bristle brush containment ring attached that surrounds the drill bit and prevents metal chips, composite dust, and coolant fluid to spoil or damage surfaces or structures adjacent to the area of the drilling process. In the prior art, such a bristle brush containment ring is not available.

10     **[032]**     In one embodiment, the present invention provides a drill nozzle that may be attached to a prior art numerically controlled drill jig using adjustable slides that make it possible to extend or retract the drill nozzle of the present invention as needed due to the size of the drill bit used for a certain application. Therefore, the use of the drill nozzle of the present invention is universal and not limited to a specific application, thus providing an advantage over prior art drill motor attachments. The drill nozzle according to one embodiment of the  
15     present invention may be used universally as an attachment to a variety of drill motor units providing coolant injection toward a drill bit and vacuum extraction of drilling debris during the drilling process on non-flat surfaces as well as flat surfaces. Consequently, the use of the drill nozzle according to one embodiment of the present invention is not limited to aircraft manufacturing but  
20     may be used for numerous industrial/commercial applications.

**[033]**     Referring now to Figures 1, 2, 3, and 4, an external view of a drill nozzle 10 is illustrated according to one embodiment of the present invention. The drill nozzle 10 may include a housing 11 and a bristle brush ring 12. The housing 11 may include a first section 13 and a second section 15. The first  
25     section 13 may have a cylindrical elongated shape and a hollow interior and may extend along a first axis 14. The second section 15 may have a cylindrical elongated shape and a hollow interior and may extend downward from the first section 13 along a second axis 141 in a preferably 90-degree angle in reference to the first axis 14. The first section 13 intersects with the second section 15 of  
30     the housing 11, as shown in Figure 1. The first section 13 of the housing 11

may have a first open end 16 and a second open end 17 opposite from the first open end 16. The first open end 16 and the second open end 17 may be terminal ends spaced apart along the first axis 14. The first section 13 of the housing 11 may include an air intake 18, and at least two coolant inlets 19. The  
5 second section 15 of the housing 11 may include a vacuum tube 21 (as shown in Figures 5, 6, and 7) and at least two mounting flanges 22. The second section 15 of the housing 11 may be located proximate to the second open end 17 of the first section 13. The first open end 16 and the second open end 17 of the first section 13 of the housing 11 define a spherical internal chamber 24  
10 therein that may be in connection with the vacuum tube 21, as shown in Figures 3, 5, and 7. The air intake 18 has a preferably cylindrical shape and extends the housing 11 downward along the second axis 141, preferably in a right angle to the first axis 14. The air intake 18 may be located proximate to the second open end 17 and above the second section 15 of the housing 11. The at least  
15 two coolant inlets 19 may have a cylindrical shape and extend the housing 11 sideward, preferably in a right angle to the first axis 14. The air intake 18 may have a barbed fitting 181 for attaching a hose delivering pressurized air, as shown in Figure 3. The hose delivering pressurized air may be secured to the air intake 18 using a band clamp or similar devices. Each of the at least two  
20 coolant inlets 19 may have a barbed fitting 191 for attaching a hose delivering coolant fluid, as shown in Figure 3. A different hose delivering coolant may be attached to each coolant inlet 19 using a band clamp or similar device.

**[034]** As shown in Figure 3, the at least two mounting flanges 22 of the second section 15 of the housing 11 may be located proximate to the  
25 intersection of the first section 13 and the second section 15 and may extend sideward from the housing 11 to opposite sides, preferably in a right angle to the first axis 14 and the second axis 141, as shown in Figures 1 and 3. Furthermore, each mounting flange 22 may include an aperture 23 for mounting the housing 11 to a drill motor unit 30, as shown in Figure 9. The second  
30 section 15 of the housing 11 may have an external vacuum source (not shown)

attached, which may be secured with a band clamp or similar device.

[035] The housing 11 of the drill nozzle 10 may be made of acrylonitrile butadiene styrene (ABS) plastic and may be manufactured in one piece using a fused deposition modeled process, a rapid prototyping technology. The bristle brush ring 12 may be attached to the first section 13 of the housing 11 by wrapping the bristle brush ring 12 around the housing 11 proximate to the first open end 16 (shown in Figure 1) and may be secured using a band clamp or similar device (not shown). The bristle brush ring 12 is available for any outer diameter 161 of the first open end 16. Furthermore, the bristle brush ring 12 used for the containment of metal chips, composite dust, and coolant fluid is commercially available.

[036] Referring now to Figures 5, 6, 7, and 8, an internal view of a drill nozzle 10 is illustrated according to one embodiment of the present invention. The first open end 16 may have a first outer diameter 161 and a smaller first inner diameter 162. The second open end 17 may have a second outer diameter 171 and a smaller second inner diameter 172 (shown in Figure 6). The first inner diameter 162 may be larger than the second inner diameter 172. The second inner diameter 172 of the second open end 17 of the housing 11 may be designed to be large enough to allow a drill bit pass through and to move freely.

[037] As illustrated in Figures 5, 6, and 7, each coolant inlet 19 includes an integrally molded coolant nozzle 25 for receiving coolant from an external source (not shown). Each coolant nozzle 25 may branch off into at least two coolant passageways 26 that may include coolant jets 27 at the opposite end. The coolant passageways 26 are integrally molded into the first section 13 of the housing 11 around the chamber 24 such that the coolant jets 27 are evenly spaced around the circumference of the first open end 16 and between the first outer diameter 161 and the first inner diameter 162 of the first end 16. Further, the coolant jets 27 may be designed such that the expelled coolant fluid is directed towards the first axis 14, as shown in Figure 6. Such designed coolant



jets 27 will enable that a drill bit passing through the first section 13 of the housing 11 along the first axis 14 may be engulfed with coolant fluid during the drilling operation.

[038] A shown in Figures 5, 6, 7, and 8, the air intake 18 may include a manifold air nozzle 28 that may be integrally molded into the air intake 18 during the manufacturing process of the housing 11. The air nozzle 28 may be located at the back of the internal chamber 24 proximate to the second open end and above the vacuum tube 21 along the second axis 141, as shown in Figures 5, 6, and 7. The air nozzle 28 may receive pressurized air from an external source (not shown) that may be attached to the air intake 18. The air nozzle 28 may provide a thrust-vectorized down draft 29 into the vacuum tube 21, as shown in Figures 3 and 7. The thrust-vectorized down draft 29 may function as an air curtain to prevent the rear escape of metal chips and composite dust that are generated during the drilling process through the second open end 17 of the housing 11.

[039] As illustrated in Figures 5 and 6, the internal chamber 24 may be in communication with the vacuum tube 21, wherein the vacuum tube 21 may intersect with the internal chamber 24 proximate to the second open end 17. This design may enable the removal of drilling debris generated during the drilling process as well as remaining coolant fluid through the vacuum suction. This process may be also supported by the thrust-vectorized down draft 29, as shown in Figures 3 and 7.

[040] Referring now to Figures 9, 10, 11 and 12, a drill nozzle 10 attached to a drill motor unit 30 is illustrated according to another embodiment of the present invention. A mounting device 40 may include two horseshoe brackets 31 that may be attached to the base section of the drill motor unit 30, as shown in Figures 9 and 10. The mounting device 40 may further include a mounting plate 32 in rigid connection with the horseshoe brackets 31 and two adjustable slides 33. Each mounting flange 22 of the drill nozzle 10 may be connected with the mounting plate 32 using one of the adjustable slides 33. A mounting

screw 34 may be used to secure the adjustable slide 33 to the mounting flange 22 after insertion of the adjustable slide 33 through the aperture 23 in the mounting flange 22. The mounting device 40 may be designed to position the drill nozzle 10 such that a drill bit 35 may pass through the internal chamber 24 of the housing 11, such that it may extend coaxially with the first axis 14, entering the chamber 24 from the second open end 17 of the housing 11 and exiting the chamber at the first open end 16. Further, the drill nozzle 10 may be mounted to the drill motor unit 30 such that the air intake 18 is pointing downward and the vacuum tube 21 is pointing downward along the first axis 14.

5 [041] The distance of the drill nozzle 10 from the drill motor unit 30 may be adjusted according to the size of the drill bit by extending or retracting the adjustable slides 33. Figure 9 shows the drill nozzle 10 in a retracted position while Figure 12 shows the drill nozzle 10 in an extended position. A locking screw 36 may be used to hold the drill nozzle 10 in the desired position relative to the drill motor unit 30, as illustrated in Figures 9, 10, and 12.

15 [042] A method for providing coolant to a drill bit and for vacuum extracting drilling debris generated during the drilling process on non-flat surfaces may include the steps of: attaching a drill nozzle 10 to a drill motor unit 30, adjusting the distance of the drill nozzle 10 from the drill motor unit 30 according to the desired size of the drill bit 35 by extending or retracting the adjustable slides 33 and securing the desired position with the locking screw 36, providing coolant fluid through the coolant inlet 19 toward the coolant jets 27, expelling coolant fluid towards the drill bit 35, starting to drill a hole into a non-flat surface, vacuum extracting the drilling debris and remaining coolant fluid through the vacuum tube 21, preventing metal chips and composite dust from exiting the drill nozzle 10 towards the drill motor unit 30 by providing pressurized air through the air intake 18 and by providing a thrust-vectored down draft 29 into the vacuum tube 21 using the manifold air nozzle 28. Furthermore, by attaching the bristle brush ring 12 to the first section 13 of the housing 11, metal chips, composite dust, and coolant fluid may be contained inside the bristle brush ring

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12 preventing damage and soiling of surrounding structures and areas. The drill motor unit 30, to which the drill nozzle may be attached, may be a drill motor unit of a prior art numerically controlled drill jig. The non-flat surface may be, for example, a leading edge extension spar of the F-18 aircraft.

5   **[043]**       Therefore, by using the coolant feed drill nozzle 10 with thrust-  
vectorfed intake of the present invention, it may be possible to drill holes having  
a high quality and accuracy into non-flat surfaces while using the advantages of  
a numerically controlled drill jig. Although, the drill nozzle 10 as disclosed in  
one embodiment of the present invention may be most effective when attached  
10 to the drill motor unit 30 of a numerically controlled drill jig and for drilling holes,  
for example, into a leading edge extension spar of the F-18 aircraft, it may be  
used with other drill motor units and applications as well.

**[044]**       It should be understood, of course, that the foregoing relates to  
preferred embodiments of the invention and that modifications may be made  
15 without departing from the spirit and scope of the invention as set forth in the  
following claims.